

Work Order ID 80230

Wednesday, February 15, 2012 9:26:24 AM

80230

Ship Friday

Page 1

Item ID: D3939-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cover

Stop ***NS2***

Start Date: 2/15/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/15/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 12-02-15 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3939

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*Prog Rev: *A*

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

W 12-02-16 (2)*W* 12-02-16 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3939-1

Revision ID:

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Start Date: 2/15/2012 Start Qty: 2.00 *2*

Required Date: 2/15/2012 Req'd Qty: 2.00 *2*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center ID

120

120

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

5/2/2/16

(72)

130

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

2 BL 122-16.

140

140

QC

Quality Control

QC7-Inspect Chemical Conversion Coat

Memo

0.00

0.00

2 XPM 12/2/16

W/O:		WORK ORDER CHANGES					
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Revision ID:

Stop ***NS2***

Item Name: Cover

Start Date: 2/15/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 2/15/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: 137

0.00

150

Packaging

Memo

0.00

Packaging

Plak 12

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/2/17

MF
12-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, February 15, 2012 9:26:23 A

Page 1
1

Work Order ID: 80230

Parent Item: D3939-1

Parent Item Name: Cover

Start Date: 2/15/2012

Required Date: 2/15/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.15 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050 6061-T6 .050 Sheet		Purchased	No			100	sf	114.3600	0.0625	0.1315789			

Location:

MAT021

Loc Qty

114.36

Loc Code

113216

10

114799

89.36

114993

15

W 12-02-16

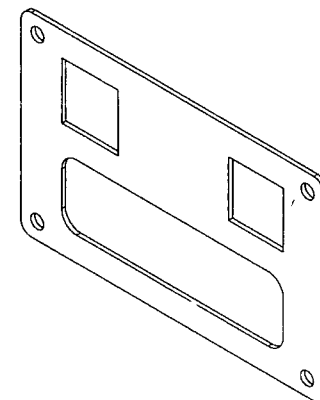
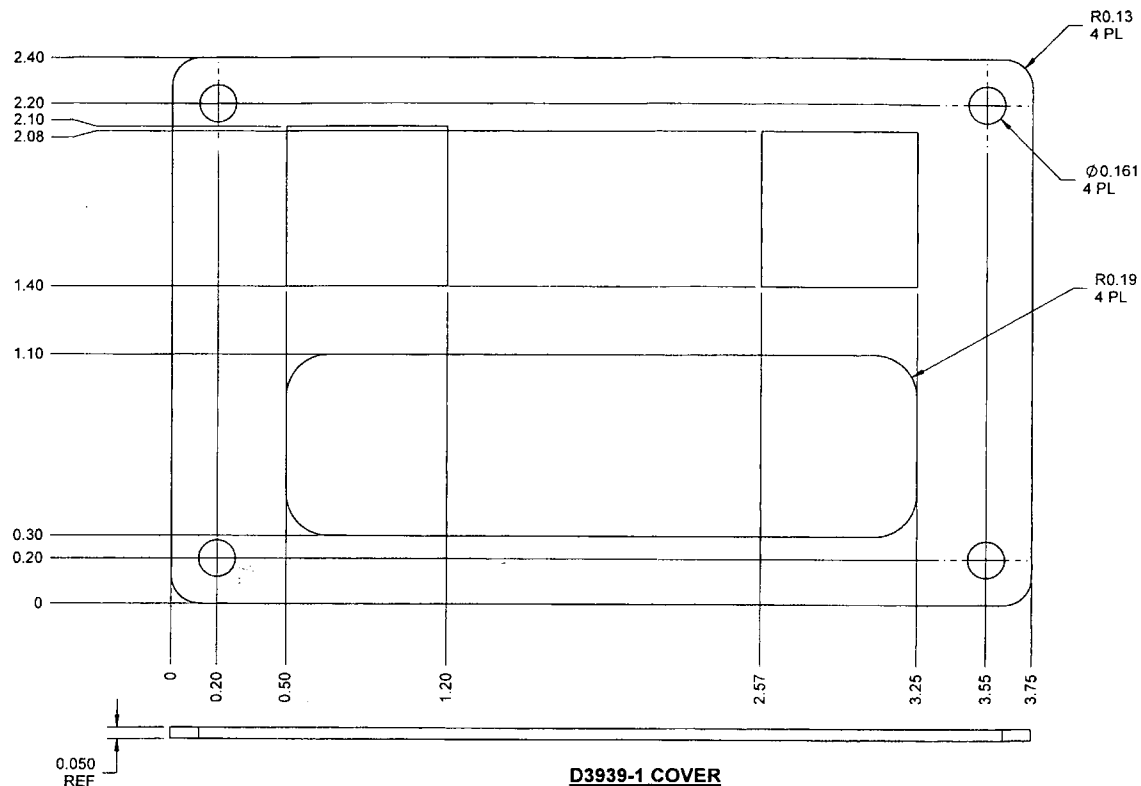
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#80230

RELEASED
-05-14-2009

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3939-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A		NEW ISSUE		09.05.01	
REV	DESCRIPTION	BY	DATE		
DESIGN				DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN					
CHECKED				DRAWING NO.	REV. A
MFG. APPR.	N/A			D3939	SHEET 1 OF 2
APPROVED				TITLE	SCALE
DE APPR.	N/A			COVER	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
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Work Order: 80230

Part Number: D3939-1

COVEN : description

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Inspection Dwg: D3939, Rev: A

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.161	+0.005-0.001	0.165	✓		V&N	H3-02
3.75	+/-0.030	3.753	✓		V&N	"
2.40	+/-0.030	2.40	✓		V&N	"
0.50	+/-0.030	0.497	✓		V&N	"
1.10	+/-0.030	1.10	✓		V&N	"
1.40	+/-0.030	1.399	✓		V&N	"

Measured by:	<i>[Signature]</i>	Date:	12.02.16
Audited by:	<i>[Signature]</i>	Date:	12/02/16
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A			KJ/MLM	